



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3538-1**Job Sheet 202142****Part No:** D3538-1**Job Qty:** 12 pcs**Part Name:** Hinge Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/21/19**Job Tracking No:****Due Date:** 11/15/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP Rev:A New Issue 06-10.03 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	11/15/19	11/15/19	0.00	0.11	Bandsaw - 1		mon 10/11/19
110	HAAS 4 Axis - B4B	12 pcs	11/15/19	11/15/19	0.09	7.41	HAAS - 1 - B4B		mon 10/11/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	12 pcs	11/15/19	11/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mon 10/11/19
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

**Container No:** S231229**Part:** D3538-1**Job No:** 202142**Serial No/Batch:** S231229**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 11/13/19

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130 QC 8	12 pcs	11/15/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	Am 19/11/18
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	12 pcs	11/15/19	0.00 0.29	Handfinish - 1 - 1 - B4B	BEB 19-11-19.
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

					B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)-B4B	12 pcs	11/15/19	0.00	0.26	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	12 pcs	11/15/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	12 pcs	11/15/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	

BL 19-11-22

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		Packaging 3 - 13 - B4B						
		Packaging 3 - 14 - B4B						
		Packaging 3 - 15 - B4B						
		Packaging 3 - 16 - B4B						
		Packaging 3 - 17 - B4B						
		Packaging 3 - 18 - B4B						
		Packaging 3 - 19 - B4B						
		Packaging 3 - 20 - B4B						
		Packaging 3 - 21 - B4B						
		Packaging 3 - 22 - B4B						
		Packaging 3 - 23 - B4B						
		Packaging 3 - 24 - B4B						
		Packaging 3 - 25 - B4B						
		Packaging 3 - 26 - B4B						
		Packaging 3 - 27 - B4B						
		Packaging 3 - 28 - B4B						
		Packaging 3 - 29 - B4B						
		Packaging 3 - 30 - B4B						
		Packaging 3 - 31 - B4B						
		Packaging 3 - 32 - B4B						
		Packaging 3 - 33 - B4B						
		Packaging 3 - 34 - B4B						
		Packaging 3 - 35 - B4B						
		Packaging 3 - 36 - B4B						
		180	QC 21 - SA	12	11/15/19	0.00 0.00	QC 21 - SA - 21	DAS
				pcs			QC 21 - SA - 70	21
							QC 21 - SA - 53	53

Part Op 100 - Cut blanks 1.500" long
 Descriptions: 110 - (HAAS CNC Vertical Machine), 1-Machine as per Folio FA651 and Dwg D3538
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: 10:00 o.t.: 8:00 Finish: 10:30
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X1.250	6061-T6 Bar 1.25 X 1.25	2.2800 ft (.19 ea)	100-Bandsaw - 1	91239 SS-158

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X1.250	2	15	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 202142
Description: Hinge Bracket		Part Number: D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.746	/		vern	mmL-05
0.375	+/-0.010	0.372	/		↓	
0.241	+/-0.010	.240	/			
0.830	+/-0.010	.830	/			
Ø0.172	+0.005/-0.001	0.173	/			
Ø0.400	+0.006/-0.001	0.399	/			
0.031	+/-0.010	.028	/			
1.31	+/-0.030	1.309	/			
0.375	+/-0.010	0.370	/			
0.99	+/-0.030	0.988	/		Heigh G	3100C
0.125	+/-0.010	.123	/		vern	mmL-05
R0.19	+/-0.030	0.190	/		RL	
0.083	+/-0.010	0.080	/			
93°	+/-0.5°	93°	/		Angle M	CNC-19
0.674	+/-0.010	0.666	/		Heigh G	3100G
R0.38	+/-0.030	0.375	/		RL	
Ø0.172	+0.005/-0.001	.172	/		vern	mmL-05

Measured by: mmL	Audited by: JML	Prototype Approval:	N/A
Date: 19/11/18	Date: 19/11/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date :	Sequence #:	QTY Affected :		MRB (QSI042)																													
Description Work Order Deviation		Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details:				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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		Completed By Lead hand / Supervisor QC / QA Coordinator																															